

Date: Tuesday, 19/08/2008 11:23:23 AM  
 User: Julie Lecocq

## Process Sheet

<b>Customer</b> :	CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> :	212/205 HIGH AFT X-TUBE ASSEMBLY
<b>Job Number</b> :	41402		
<b>Estimate Number</b> :	10257		
<b>P.O. Number</b> :		<b>Part Number</b> :	D212664201
<b>This Issue</b> :	19/08/2008	<b>S.O. No.</b> :	
<b>Prsht Rev.</b> :	NC	<b>Drawing Number</b> :	D212-664-241 REV C
<b>First Issue</b> :	//	<b>Project Number</b> :	N/A
<b>Previous Run</b> :	41401	<b>Drawing Revision</b> :	C
		<b>Material</b> :	
<b>Written By</b> :		<b>Due Date</b> :	05/09/2008
<b>Checked &amp; Approved By</b> :	JUD 08.8.19	<b>Qty:</b>	1 Um: Each
<b>Comment</b> :	Est Rev:E 04.02.16 Reformat K/DS Est Rev:F 06-03-29 Remove Comments on Pick List JLM Est Rev:G 07-04-30 As per Rev C JLM Est Rev:H 08-05-22 up date Qty of rubber cushion DD verified by:EC		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
-----	----	------------------



JUD 08.8.28 S 08/09/05



Comment: DOCUMENT CONTROL

Photocopy bluefile and create labels as per PPP D212-664-201CHG003

2.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------



Comment: PACKAGING RESOURCE #1

3.0	D212664201TRN	Crosstube Turning Detail
-----	---------------	--------------------------



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

CROSSTUBE TURNING DETAIL

batch B40800

DP 8-8-21

4.0	BENDING	BENDING MACHINE - SKIDTUBES
-----	---------	-----------------------------



Comment: BENDING MACHINE

Bend tube as per Dwg D212-664-241 using CNC bender program 212-af and Folio FT007

5.0	QC15	DIMENSIONAL CHECK OF X-TUBES
-----	------	------------------------------



Comment: DIMENSIONAL CHECK OF X-TUBES

J 08.06.25 (1)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR: _____		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Tuesday, 19/08/2008 11:23:23 AM  
User: Julie Lecocq

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 212/205 HIGH AFT X-TUBE ASSEMBLY

Job Number: 41402

Part Number: D212664201

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

CROSSTUBES

CROSSTUBES RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Drill pilot holes in tube as per Dwg D212-664-241 using drill Jig DT8550 & DT8551

2-Ream hole to finish size in tube as per Dwg D212-664-241 using drill Jig DT8550 & DT8551. Check dimensions between holes, both sides on both cuffs, to ensure alignment with saddle holes.

3-Deburr & Inspect for surface damage. Repair damage within limits as per Dwg D212-664-241.

4-Scribe part # and batch # using vibrating stylus as per Dwg D212-664-241

RT 08-08-27  
S 8-8-25  
AWM

RT 08-08-25

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



AWM 8-8-25



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1 within 24 hours of bending and drilling

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

S 26/08/26 (Y)

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 26/08/26 (Y)

10.0

OUTSIDE SERV.10

OUTSIDE SERVICES -skids



Comment: Sub-Contracting OUTSIDE SERVICES

Liquid Penetrant Inspection as per QSI 038

Issue P/O: 7094

LPI as per ASTM 1417 Level 2

Attach copy of NDT results to work order

C 208/08/28 (Y)

11.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Inspect for transit damage Ensure copy of NDT results attached to work order.

C 208/28 (Y)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 212/205 HIGH AFT X-TUBE ASSEMBLY

Job Number: 41402

Part Number: D212664201

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: DIMENSIONAL CHECK

Inspect for damage & ensure results are as per Dwg D212-664-241

*ml 08/08/24*

13.0

SPRAY PAINTING

SPRAY PAINTING



Comment: SPRAY PAINTING

1-Prime inside and outside crosstube as per QSI 005 4.2

2-Paint outside crosstube with White Imron as per QSI 005 4.2

*ml 08 09 03 (1)*

14.0

QC14

INSPECT SPRAY PAINT



Comment: Inspect Spray Paint

Then, Wrap in plastic bag to protect from scratches

*ml 08-09-04*

15.0

D29401

Support



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part number Description Batch

2 D2940-1

Support

~~40753~~

*ml 08 09 04*

16.0

D3595063530

RUBBER CUSHION



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Rubber Cushion

Batch:

39255

*ml 08 09 04*

17.0

MS2192028

Clamp(per MIL-DTL-8783C)



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part number Description Batch

4 MS21920-28

Clamp

108847

*ml 08 09 04*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 212/205 HIGH AFT X-TUBE ASSEMBLY

Job Number: 41402

Part Number: D212664201

Job Number:



Seq. #:

Machine Or Operation:

Description :

18.0

CROSSTUBES

CROSSTUBES RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1- Lightly scuff the bonded area using a 320 grit sand paper and clean the area with 41058 wash 'n' wipe

2-Install supports with magnobond as per QSI 015 Adhere for for 12 Hrs

A/R 6398 Magnobond Batch: 108966

Expiry Date: 10/2009

time: 4:00pm

3-Install clamps as per Dwg D212-664-241. Torque clamps to 80-100 in lb.

ml  
08 09 04 ①

ml 08 09 05 ①

19.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08 09 05 ①

20.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

21.0

D34281

Placard



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Placard

Batch: 39322

JS 08/09/05 (K)

22.0

AN640A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Bolt

Batch: M67971

JS 08/09/05 (K)

23.0

AN641A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bolt

Batch: M67013

JS 08/09/05 ④

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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NOTE: Date & initial all entries



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Drawing Name: 212/205 HIGH AFT X-TUBE ASSEMBLY

Job Number: 41402

Part Number: D212664201

Job Number:



Seq. #:

Machine Or Operation:

Description :

24.0

AN960JD616

Washer



Comment: Qty.: 18.0000 Each(s)/Unit Total : 18.0000 Each(s)

Washer

Batch: M167959

AS 08/09/05 (K)

25.0

MS21042L6

Nut



Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s)

Nut

Batch: M165077

AS 08/09/05 (K)

26.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

08/09/05

27.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Identify and pack for shipping as per PPP D212-664-201

08/09/05 D (1)

28.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/09/10

Job Completion



MF 08-09-08

B 41402 D 212-664-201

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

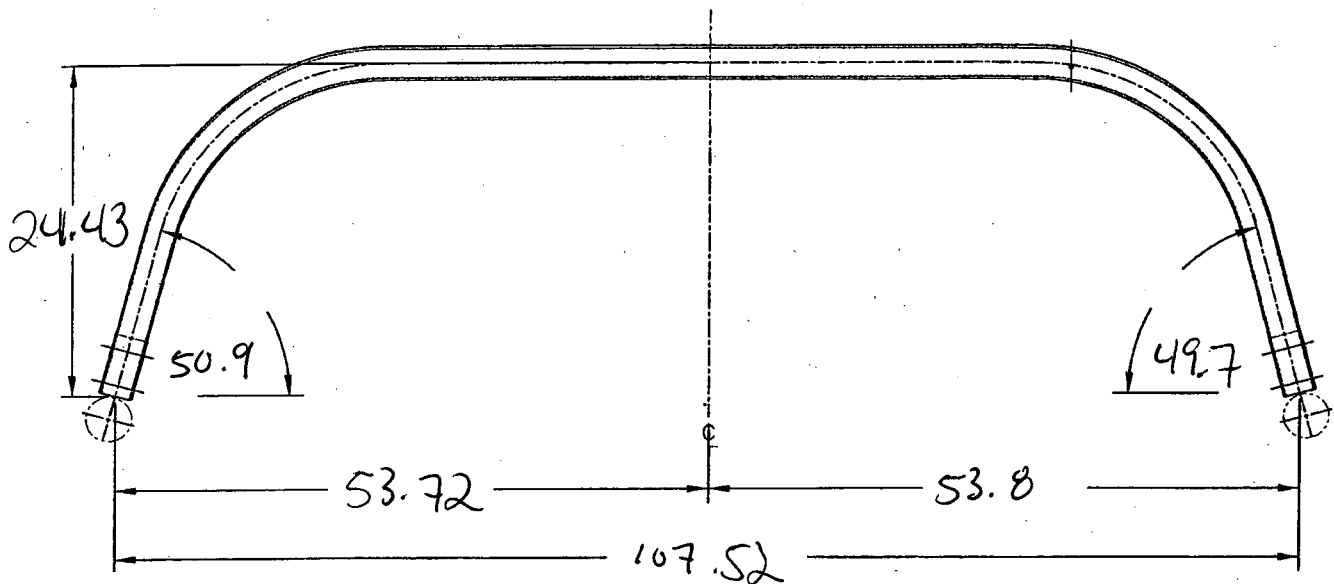
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

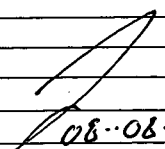
**NOTE:** Date & initial all entries

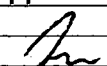

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	410402
<b>Description:</b> Crosstube High Aft (205/212)		<b>Part Number:</b>	D212-664-201
<b>Inspection Dwg:</b> D212-664-241 <b>Rev:</b> C		<b>Page 1 of 1</b>	

Required Dimension	Min	Max
Height	24.17	24.43
1/2 Span	53.59	53.85
Angle	49	52
Total Span	107.18	107.70



Comments

QC15 Inspection	
Date	

Rev	Date	Change	Revised by	Approved
A	07.02.06	New Issue	KJ/JM	
B	07.05.08	Dimensions updated per Dwg rev. C	KJ/JLM 	

**DART****RELEASED**  
07.04.24  
PER E.I.N. 289

DESIGN <i>PH</i>	DRAWN BY <i>PH</i>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>J</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D212-664-241	REV. C SHEET 1 OF 3
DATE 07.03.08		TITLE CROSSTUBE ASS'Y (205/212 HI AFT)	SCALE NTS
A	00.12.12	NEW ISSUE	
B	05.02.04	ADD HOLES FOR COMPATABILITY WITH BHT/AA SKIDTUBES	
C	07.03.08	REMOVE -1009 ABRASION STRIP; ADD MAGNOBOND 6398, CUSHION, REVERSE CLAMPS	

Qty	Part Number	Description
X	D212-664-241	CROSSTUBE ASSEMBLY (205/212 HIGH AFT)
1	D6006-129	CROSSTUBE
2	D2940-1	SUPPORT
4	D3595-063-530	RUBBER CUSHION
4	MS21920-28	CLAMP (OR MS21920-30)
A/R	MAGNOBOND 6398	ROCKWELL SPECIFICATION RBO-120-023 ADHESIVE (TEXTRON/BELL SPEC. 299-947-100, TYPE II, CLASS 2 ADHESIVE)

**GENERAL NOTES:**

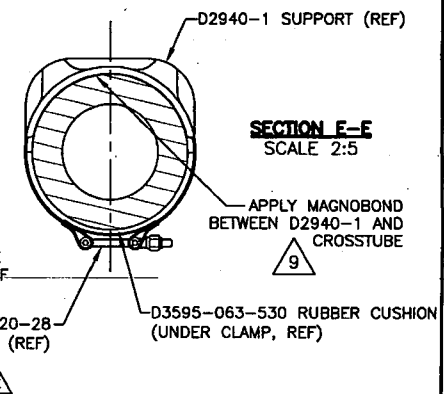
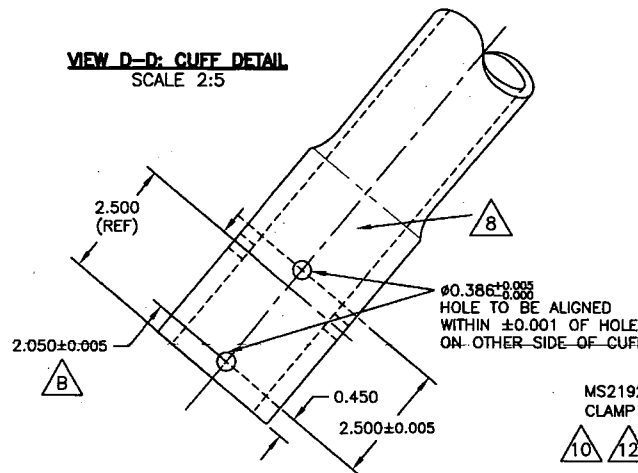
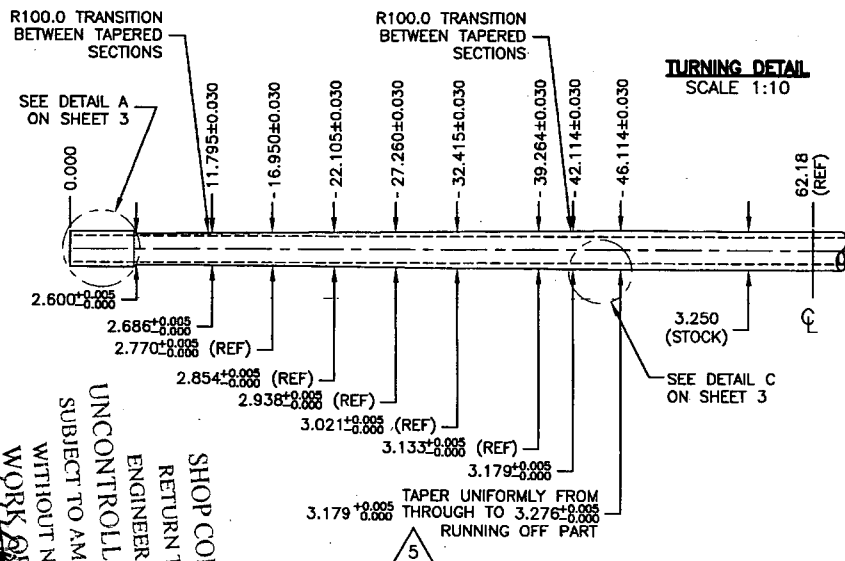
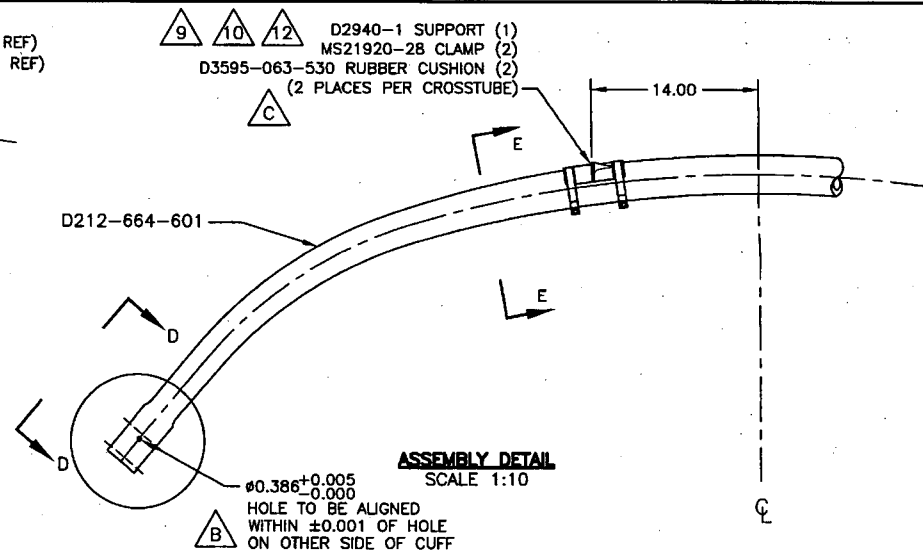
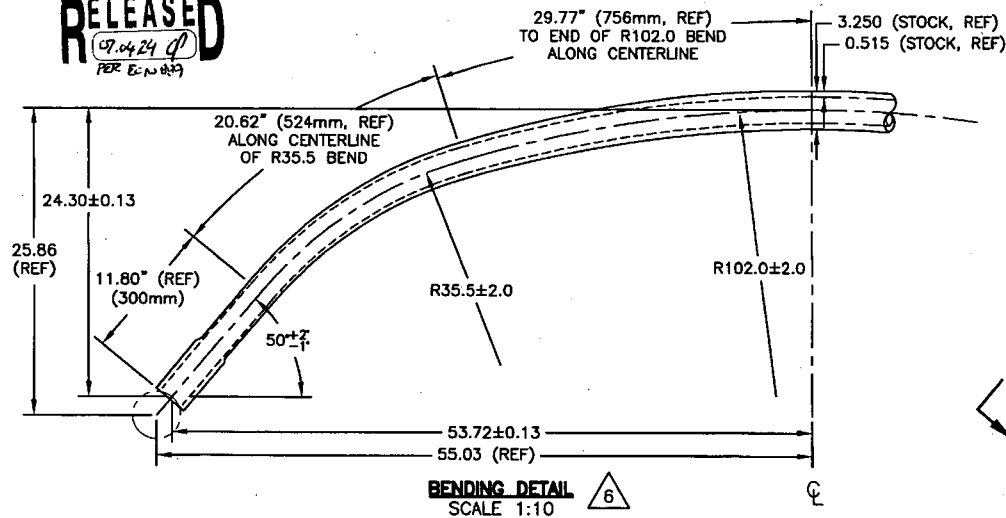
- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) MATERIAL: MANUFACTURED FROM D6006-129  
FINISHED LENGTH =  $124.36 \pm 0.020$
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2  
PAINT OUTSIDE PER DART QSI 005 4.2
- 4) PART IS SYMMETRIC ABOUT CENTERLINE
- 5) RUN-OFF PART. BLEND OUT EDGE LONGITUDINALY, TRANSITION SHOULD BE SMOOTH.
- 6) BEND PROGRESSIVELY WITH A MINIMUM OF 5 PASSES. MAXIMUM TUBE FLATTENING DUE TO BENDING IS 6% BASED ON O.D.
- 7) LIQUID PENETRANT INSPECT OUTSIDE SURFACE OF CROSSTUBE PER QSI 038.
- 8) SCRIBE DART PART NUMBER AND BATCH NUMBER IN THIS AREA WITH VIBRATING STYLUS.
- 9) INSTALL D2940-1 SUPPORT USING 0.03" TO 0.06" THICK LAYER OF MAGNOBOND 6398 PER QSI 015. LET CURE FOR 12 HOURS AFTER INSTALLATION AND PRIOR TO PACKAGING.
- 10) INSTALL MS21920-28 CLAMPS WITH D3595-063-530 RUBBER CUSHIONS TO SECURE D2940-1 SUPPORT ON TOP SIDE OF CROSSTUBE. ENSURE CLAMPS ARE OPPOSITE OF CROSSTUBE SUPPORT  
**NOTE:** MS21920-30 CLAMPS CAN BE USED TO ACCOMMODATE VARYING DIAMETERS. ENSURE THERE IS A MINIMUM OF 1.5 THREADS IN SAFETY ON THE NUTS.
- 11) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
- 12) TORQUE CLAMPS 80 TO 100 IN-LB.

SHOP COPY  
RETURN TO  
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WITHOUT NOTICE  
WORK ORDER  
NO. *4140*

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RELEASED  
07.04.24  
PER E-10-033



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DESIGN  
PH  
CHECKED  
J  
DATE  
07.03.08

DRAWN BY  
PH  
APPROVED  
J

**DART** DART AEROSPACE LTD.  
HAWKSBURY, ONTARIO, CANADA

DRAWING NO.  
D212-664-241

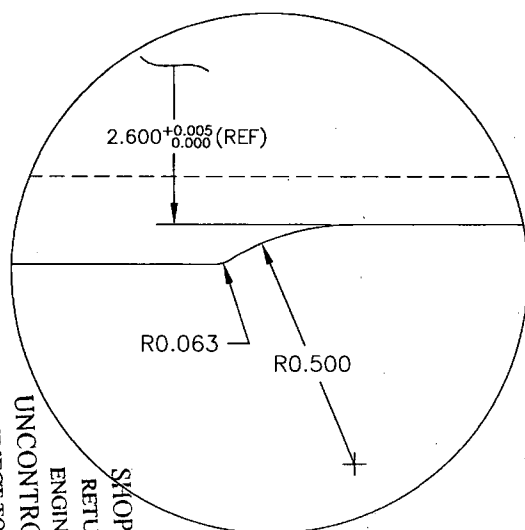
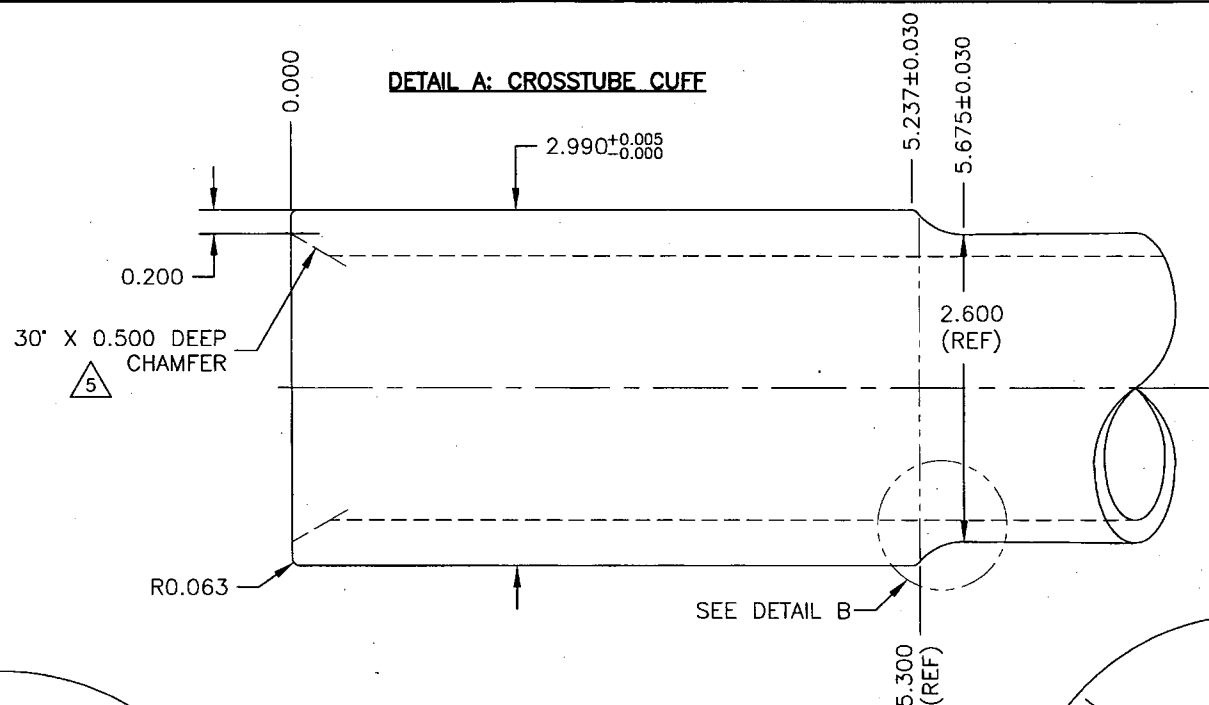
REV. C  
SHEET 2 OF 3

TITLE  
CROSSTUBE ASS'Y (205/212 HI AFT)

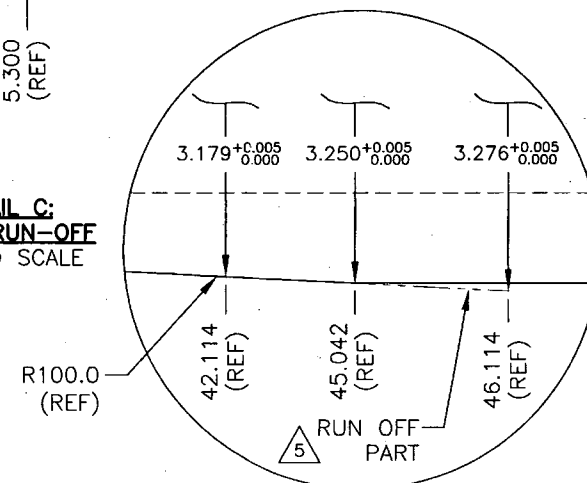
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4400  
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WORK ORDER  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE

**RELEASED**  
07.04.14  
PER ECN 869



**DETAIL C: TAPER RUN-OFF**  
NOT TO SCALE



NO 21402  
WORK ORDER  
WITHOUT NOTICE  
SUBJECT TO AMENDMENT  
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SKIP COPY

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THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.		CHECKED	APPROVED		DRAWING NO. D212-664-241
		DATE 07.03.08	TITLE CROSSTUBE ASS'Y (205/212 HI AFT)		SCALE 1:1



# LIQUID PENETRANT TEST REPORT

P - 1454 1

PAGE 1 OF 1

CLIENT	DART AEROSPACE	DATE	AUG 28, 2008	TIME	AM <input type="checkbox"/> PM <input type="checkbox"/>
ATTENTION	LINDA LACELLE	ACUREN JOB NO.	188 08 1454		
ADDRESS	1270 ABERDEEN ST HAWKESBURY, ONT.	PO/VO No.			
		WORK LOCATION	HAWKESBURY, ONT.		
		ACCEPTANCE STD.	ASTM 1417/QSI-038 <input checked="" type="checkbox"/>	REV./DATE	2005
PROJECT	412 HIGH AFT X TUBES, 212/205 HIGH FED X TUBES, 212/205 HIGH AFT X TUBES, 206L AFT X TUBE.				
ITEM(S) EXAMINED	JOB#S 41153, 41154, 41155, 41391, 41392, 41401, 41402.				

JOB DESCRIPTION	PROCEDURE NO. LT-0002	REV./DATE	TECHNIQUE NO. LT-TECH2	REV./DATE
PART NO.	D412664203 / D212664101 / D212664201 / D206667203.		MATERIAL	ALODINED ALUM.
SCOPE	WET FLOURESCENT LIQUID PENETRANT INSPECTION CARRIED OUT ON 100% EXTERNAL SURFACE			

## TEST DETAILS

METHOD	<input checked="" type="checkbox"/> FLUORESCENT	<input type="checkbox"/> VISIBLE	<input checked="" type="checkbox"/> WATER WASH	<input type="checkbox"/> SOLVENT REMOVABLE	<input type="checkbox"/> POST EMULSIFIED
FAMILY BRAND	MAGNAFLUX		BLACK LGHT8171	<input type="checkbox"/> OUTPUT > 1000 $\mu$ W/cm <sup>2</sup>	<input type="checkbox"/> AMBIENT < 2 fc
PENETRANTZL67	MINIMUM DWELL TIME	45 MIN.	LIGHTING EQUIP.	<input type="checkbox"/> FLASHLIGHT	<input type="checkbox"/> TROUBLELIGHT
PENETRANT REMOVER H2O	MINIMUM DRY TIME	>10 MIN.	OTHER	CAL JUNE 16 08	
DEVELOPER SKDS2	MINIMUM DWELL TIME	10 MIN.	LIGHT METER S/N	CAL DUE DATE	
DEVELOPER TYPE	<input checked="" type="checkbox"/> NON AQUEOUS	<input type="checkbox"/> AQUEOUS	<input type="checkbox"/> DRY		

## TEST SURFACE

SURFACE CONDITION	<input type="checkbox"/> AS GROUND	<input type="checkbox"/> AS WELDED	<input type="checkbox"/> MACHINED	<input type="checkbox"/> SHOT BLASTED	<input checked="" type="checkbox"/> CLEAN BARE METAL
SURFACE TEMPERATURE	<input type="checkbox"/> < - 4°C / 20°F	<input type="checkbox"/> - 4°C / 20°F TO 10°C / 50°F	<input type="checkbox"/> 10°C / 50°F TO 52°C / 125°F	<input type="checkbox"/> > 52°C / 125°F	

## RESULTS- (☐ METRIC ☒ IMPERIAL)

FLUORESCENT LIQUID PENETRANT INSPECTION  
CARRIED OUT ON 100% EXTERNAL ☒  
SURFACE ON:

412 HIGH AFT X TUBE JOB#S 41153, 41154.  
212/205 HIGH FED X TUBES JOB# 41155.  
212/205 HIGH AFT X TUBES JOB#S: 41401, 41402 ☒  
206L AFT X TUBE JOB#S: 41391, 41392.

RESULTS: NO INDICATION OF DEFECTS. ☒  
ITEMS ACCEPTABLE TO STANDARD ☒

**Scope of Services**  
The agreement of Acuren Group Inc. to perform services extends only to those services provided for in writing. Under no circumstances shall such services extend beyond the performance of the requested services. It is expressly understood that all descriptions, comments and expressions of opinion reflect the opinions or observations of Acuren Group Inc. based on information and assumptions supplied by the owner operator and are not intended nor can they be construed as representations or warranties. Acuren Group Inc. is not assuming any responsibilities of the owner operator and the owner operator retains complete responsibility for the engineering, manufacture, repair and use decisions as a result of the data or other information provided by Acuren Group Inc. In no event shall Acuren Group Inc.'s liability in respect of the services referred to herein exceed the amount paid for such services.

**Standard of Care**  
In performing the services provided, Acuren Group Inc. uses the degree, care and skill ordinarily exercised under similar circumstances by others performing such services in the same or similar locality. No other warranty, expressed or implied, is made or intended by Acuren Group Inc.

## SIGNATURES

CLIENT REPRESENTATIVE		DTR# E 19934	
TECHNICIAN (SIGNATURE):		REPORT REVIEWED BY:	
NAME (PRINT):	JASON HEWETT	NAME INITIALS	
	1 <sup>ST</sup> TECHNICIAN	2 <sup>ND</sup> TECHNICIAN	
CGSB LEVEL	2	CGSB LEVEL	SNT LEVEL
CGSB REG. No	6156	CGSB REG. No	

WHITE - CLIENT COPY

CANARY - OFFICE COPY

PINK - TECHNICIAN COPY

GOLD - OFFICE COPY